

20-7904



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9712

Job Sheet 203261



Part No: 646.9712

Job Qty: 16 pcs

Part Name: Body

15 pcs SBL 19/12/04



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/10/19

Description:

Note: DWG 646.9700 REV.H IPP REV:A NEW ISSUE 13-06-20 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	16 pcs		12/10/19	0.00	320.00	Bandsaw - 1	DAS 23	# 19/12/04
110	HAAS 4 Axis - B4B	16 pcs 15		12/10/19	1.00	19.29	HAAS - 1 - B4B	9-55	
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		148/581 19/12/04
120	QC 2	16 pcs 15		12/10/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		SBL 19/12/04
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S236376



Part: 646.9712

Job No: 203261

Serial No/Batch: S236376

Revision: H

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/01/19

					QC 2 - 63		
					QC 2 - 8		
					QC 2 - 66		
					QC 2 - 64		
					QC 2 - 65		
					QC 2 - 5		
					QC 2 - 71		
					QC 2 - 73		
					QC 2 - 69		
					QC 8 - 12		
					QC 8 - 14	2019/12/04	
					QC 8 - 17		
					QC 8 - 20		
QC 8 - 25							
QC 8 - 3							
QC 8 - 32							
QC 8 - 33							
QC 8 - 35							
QC 8 - 39							
QC 8 - 4							
QC 8 - 44							
QC 8 - 45							
QC 8 - 49							
QC 8 - 58							
QC 8 - 8							
QC 8 - 9							
QC 8 - 68							
QC 8 - 67							
QC 8 - 1 (A)							
QC 8 - 47							
QC 8 - 40							
QC 8 - 52							
QC 8 - 23							
QC 8 - 57							
QC 8 - 76							
QC 8 - 61							
140	Outsource - 4 - Anodize	16 pcs	12/10/19		ATG001-VC	5 2019-12-05	
150	Packaging 2-1 - Receive - B4B	16 pcs	12/10/19	0.00	0.00	Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 -	
					Plex 11/13/19 3:09 PM Dart.lajeunesse.marie		

				B4B	
				Packaging 2 - 13 - B4B	DEC 18 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
155 QC 6	16 pcs	12/10/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	JAN 06 2020 68
				QC 6 - 61	9-89
				QC 6 - 40	
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	16 pcs	12/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	cck016 DAS 80
				Packaging 3 - 4 - B4B	JAN 10 2020 9-89
				Packaging 3 - 5 - B4B	
				Plex 11/13/19 3:09 PM Dart.lajeunesse.marie	

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	15 16 pcs	12/10/19	0.00 0.00	QC 21 - SA - 21 ✓	OK 016
				QC 21 - SA - 70	21 JAN 10 2020
				QC 21 - SA - 53	9:00

Part Op 100 - (Bandsaw) Cut Blank at 7.425"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB199 DWG REV: H FOLIO REV: G 2-
debur and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG: 45323 Hard Anodize, Color Black and Prime as per Dwg 646.9700

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	9.9200 ft (.62 ea)	100-Bandsaw - 1	5223519 x 10/19/19

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S1.000X5.000	10	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body(U Channel)	0.177Inches + 0.005 - 0.001	0.182 0.176		0.177
2	Body(U Channel)	0.201Inches + 0.005 - 0.001	0.206 0.200		0.201
3	Body(U Channel)	2.246Inches ± 0.002	2.248 2.244		2.248
4	Body(U Channel)	3.426Inches ± 0.002	3.428 3.424		3.427
5	Body(U Channel)	4.593Inches ± 0.002	4.595 4.591		4.593
6	Body(U Channel)	5.633Inches ± 0.002	5.635 5.631		5.633
7	Body(U Channel)	6.651Inches ± 0.002	6.653 6.649		6.651
8	Body(U Channel)	0.352Inches + 0.005 - 0.000	0.357 0.352		0.354
9	Body(U Channel)	0.875Inches ± 0.005	0.880 0.870		0.879
10	Body(U Channel)	0.130Inches ± 0.010	0.140 0.120		0.133
11	Body(U Channel)	45.0Angle ± 0.5	45.5 44.5		45.00°

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER POHB045323



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045323

PO Date: 12/5/19

Due Date: 12/23/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

2019-12-11

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
197181	D1038-158B	D1038 Rev B		Avionics Fastener Rail : Various STC's Issue P/O: Black Anodize as per Dwg D1038 and QSI 017 4.1.10 Anodize per MIL-A-8625F Type I or IB or IC or IIB Class 2, Type III Class 2	Firmed -	X 50	12/16/19	50 pcs	0 pcs	50 pcs	\$4.96/pcs	\$248.00
Line Item Note **NEED BY DEC 16**												
203216	D5553-1	D5553 Rev A		Bracket : Various STC's ISSUE P/O: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR IIB CLASS 2 C OF C IS REQUIRED	Firmed -	X 8	12/23/19	8 pcs	0 pcs	8 pcs	\$4.96/pcs	\$39.68
203261	646.9712	646.9700 Rev H		Body : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.9700	Firmed -	X 15	12/23/19	15 pcs	0 pcs	15 pcs	\$16.21/pcs	\$243.15
Grand Total:											\$530.83	

Guerin



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (813) 632-5200

PURCHASE ORDER

POHB045323



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications

A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/11/19 4:11 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919250

Date: 17-Dec-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
50 ea	Part: D1038-58B Avionics Fastener Rail Black Anodize per MIL-A-8625F, Type II, Class2, .0004-.0010" (4 - 1 mils). Job: 26579 PO: POHB045323	Rev: B	Line: 1
8 ea	Part: D5553-1 Bracket Anodize per MIL-A-8625F, Type II, Class2, Black, .0004-.0010" (4 - 1 mils). Job: 26580 PO: POHB045323	Rev: A	Line: 2
15 ea	Part: 646.9712 Body Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 120908 Job: 26581 PO: POHB045323	Rev: H	Expiry Date: 10/20 Line: 3
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: DEC 17 2019 Certified Signature:  Made in Canada.			

DAS
68
9-89

RECEIVED

DEC 17 2019

DART AEROSPACE LTD.

Entered: ZKDate: Feb 12/2020NCR No. 20-7904

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>203261</u> Part No. <u>646, 9712</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																													
Date: <u>19/12/04</u>		Sequence #: <u>110</u>		QTY Affected: <u>1</u>		MRB (QSI042)																											
Description Work Order Deviation				Disposition		PD 19.12.04 Completed By <u>SBL 19/12/04</u> Lead hand / Supervisor <u>and 19/12/04</u> QC / QA Coordinator <u>PD 19.12.04</u>																											
the 2 slot (0,352 ^{+0,005} _{-0,000}) are under tolerance on both slot (0,350)				scrap and destroyed <u>no replace</u>																													
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>				☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up																															
		Other/Details:																															